

Day: Wednesday, 11/02/2009 1:18:37 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	TAIL ROTOR PEDAL DISABLING KIT	
Job Number :	45750	Part Number :	D3371041	
Estimate Number :	12334	Drawing Number :	D3371 REV B	
P.O. Number :		Project Number :	N/A	
This Issue :	11/02/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	B	
First Issue :	//	Type :	SMALL /MED FAB	
Previous Run :	41551	Material :		
Written By :		Due Date :	28/02/2009	Qty: 6 Um: Each
Checked & Approved By :	<u>JUD 09.02.11</u>			
Comment :	Est Rev: A Removed from 9 Digit 06-03-10 KJ			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D33711	Pedal Lock Base
-----	--------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit -Total : 6.0000 Each(s)

Pick:

* Qty	Part Number	Description	Batch
1	D3371-1	Pedal Lock Base	B22287 (5X) B22287 (1X)

2.0	D33713	Pedal Lock Cover
-----	--------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3371-3	Pedal Lock Cover	B22288

3.0	D33853	Hinge
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3385-3	Hinge	B22387

4.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING
 Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

Date: Wednesday, 11/02/2009 1:18:37 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL ROTOR PEDAL DISABLING KIT

Job Number: 45750

Part Number: D3371041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



NA W



Comment: INSPECT POWDER COAT

6.0

D27287

Dart Logo label



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2728-7 Decal

B22554

Ep09/03/18

7.0

D33737

Cam Lock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3373-7 Cam Lock

B22660

CHECK WITH PRODUCTION IF KEYED ALIKE OR UNALIKE

Ep09/03/18

8.0

AN526C832R6

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN526C832R6 Screw

M16612

Ep09/03/18

9.0

238028

3/16" Dowel Pin .5" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description

2 238-028 3/16" dia. Dowel Pin 1/2" long

A/R N/A Locktite 262

M17278

M109985

Ep09/03/18

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.

2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.

3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5

Ep09/03/18(6)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL ROTOR PEDAL DISABLING KIT

Job Number: 45750

Part Number: D3371041

Job Number:



Seq. #: Machine Or Operation: Description :

4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply locktite to lock body nut.

Qty	Part Number	Description	Batch
A/R		262 Locktite	M10005 11109985

11.0

~~D33841~~

Cyclic Sock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3384-1	Cyclic Sock	B45752

12.0

~~CBL460~~

Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	CBL-460	Loop Sleeve	M109062

13.0

~~CBL1240~~

Cable



Comment: Qty.: 1.7499 f(s)/Unit Total : 10.4996 f(s)

Pick:

Qty	Part Number	Description	Batch
20	CBL-1240	Cable	M1103227

MOX

M1107234 (4N)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble lanyard to cyclic sock as per Dwg D3384
Identify as D3384-045

15.0

~~AN960416~~

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960-416	Washer	M119356

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Job Number: 45750

Part Number: D3371041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

HX81

1/4"-20 SHCS 3/8" long



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 HX-81

1/4"-20 SHCS 3/8" long

M110383

17.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371.

Identify as D3371-041 & attach keys

Record the Key Number on page 4

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

SC 493

09/03/24

Record Key #

C 346A x 5

C 420A x 1

09/03/24

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/25

Job Completion



09-03-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3371-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

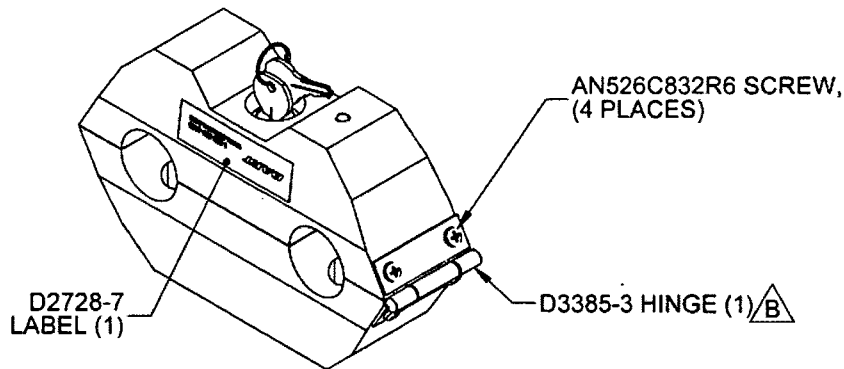
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>45750</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/24	17	<u>D3371-3</u> 1 part a screw broke because thread was not done well tried to removed screw but hole was enlarged can't not removed all screw inside	<u>AB</u> <u>Q9999</u>	Scrap & destroy	<u>EB</u> <u>09/03/24</u>	<u>EB</u> <u>09.03.24</u>	<u>AB</u> <u>Q9999</u>	<u>AB</u>

NOTE: Date & initial all entries

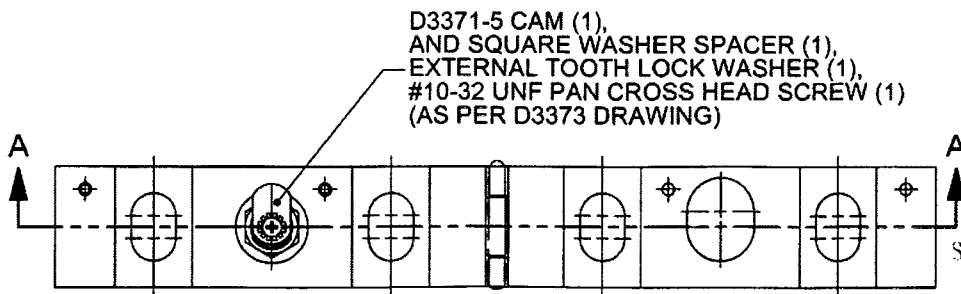
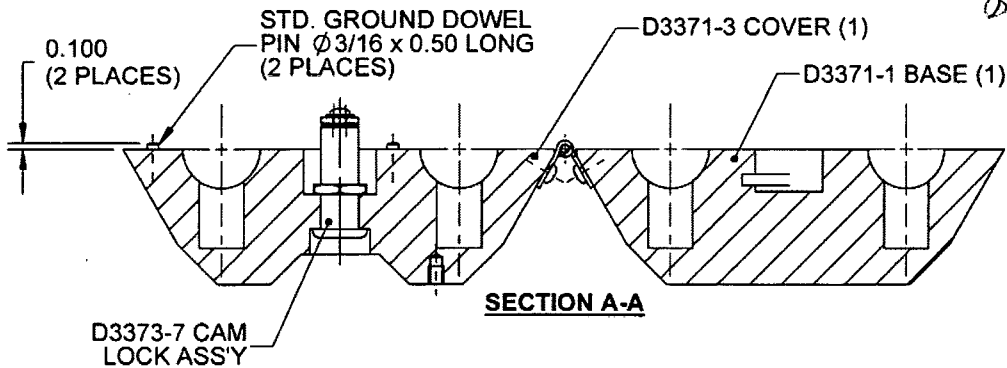
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED
[Signature]
05/04/28



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) ALL DIMENSIONS ARE IN INCHES

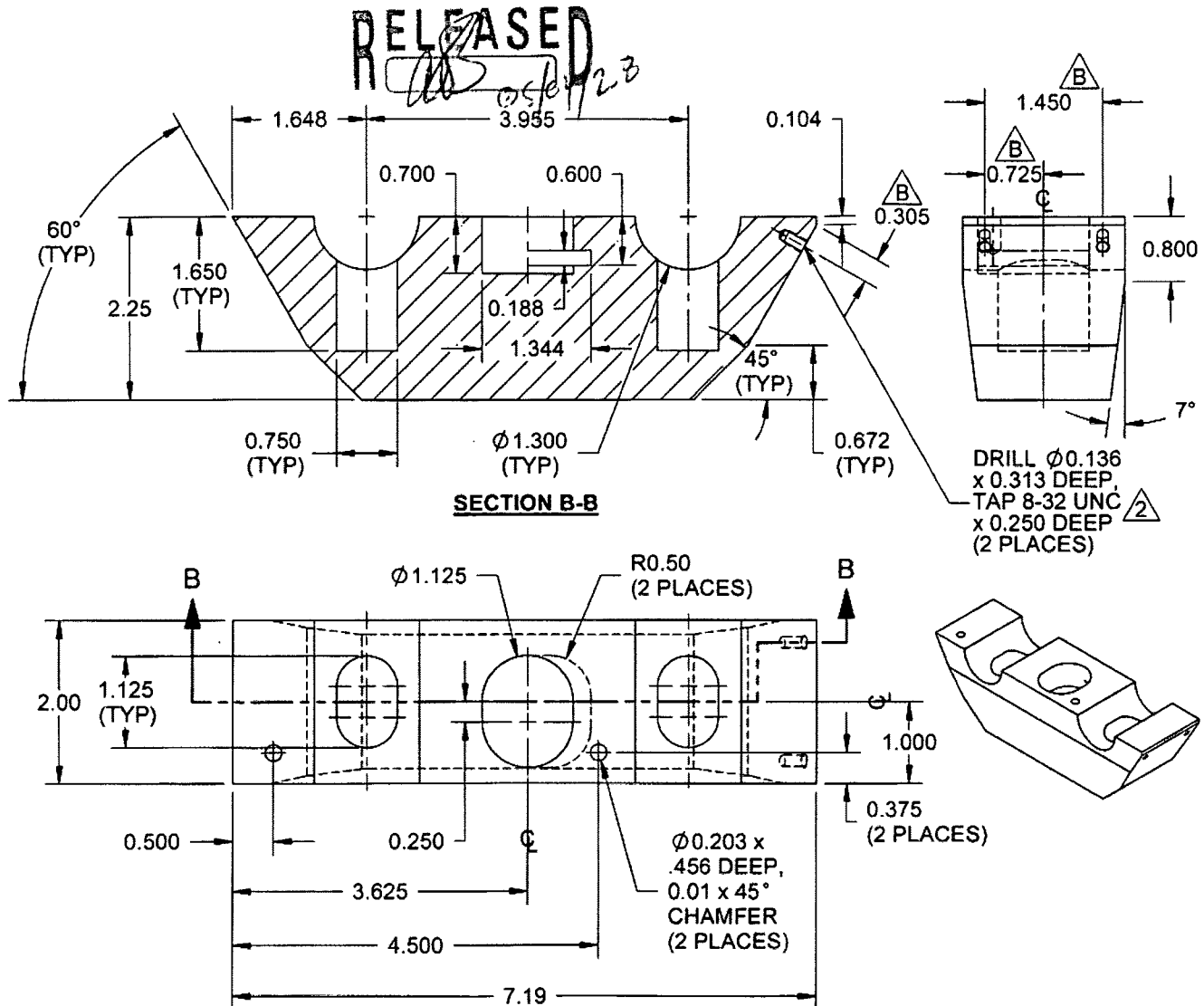
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CHECKED R	APPROVED [Signature]	DRAWING NO. D3371	REV. B SHEET 2 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

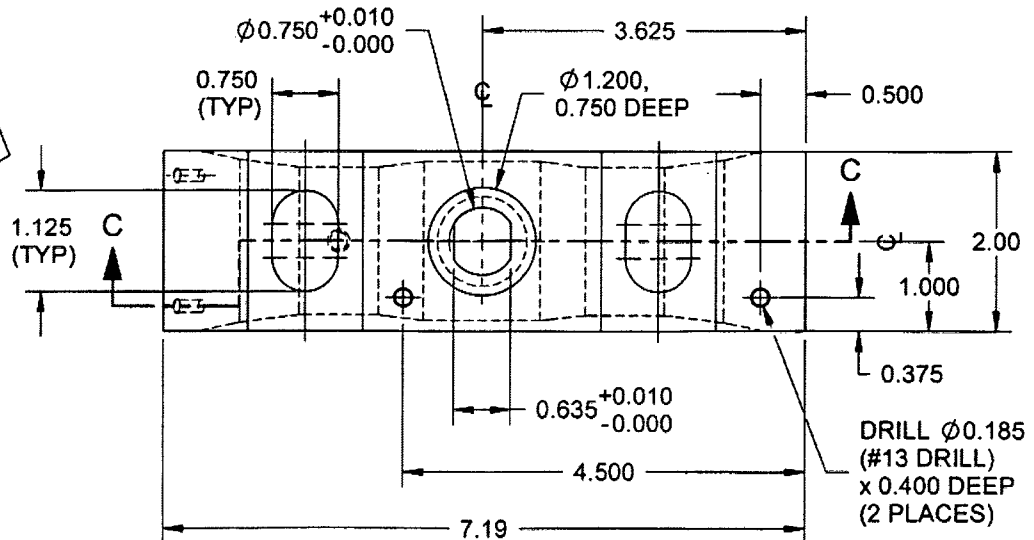
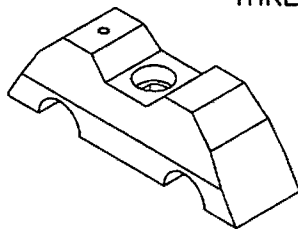
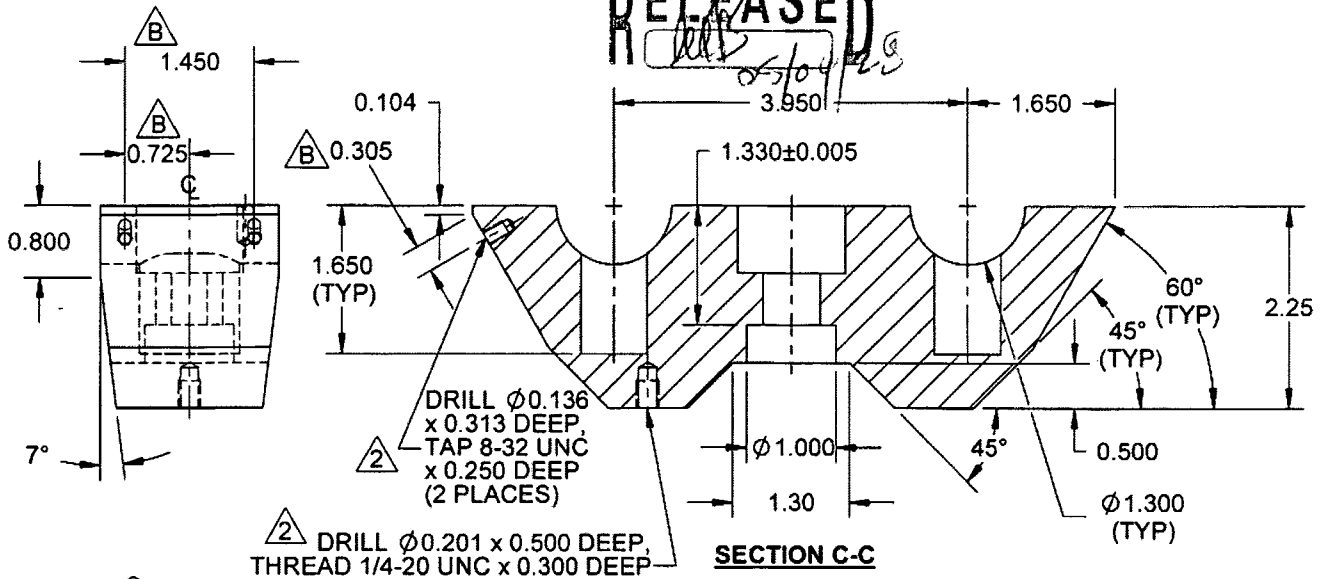
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 3 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2

RELEASED**D3371-3 COVER****NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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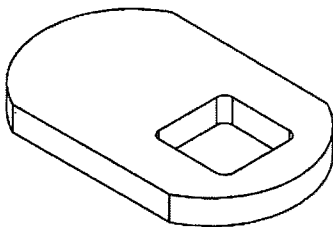
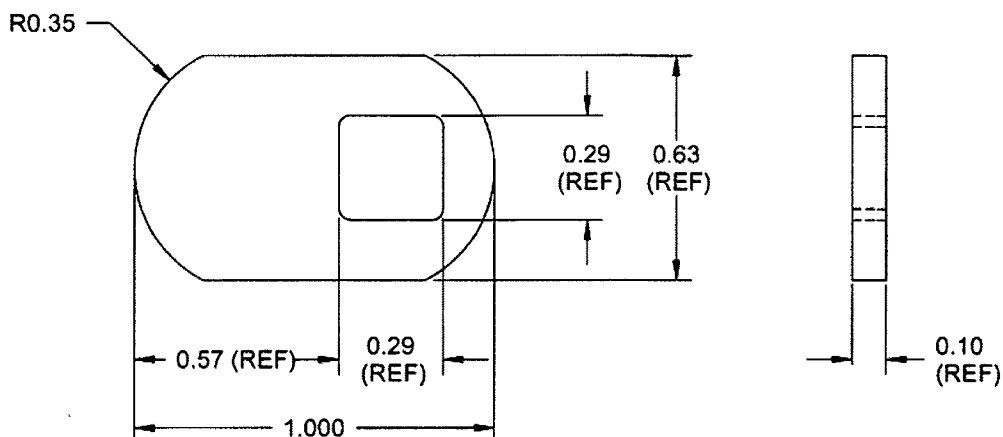
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

RELEASED
[Signature]
05/04/20

SPECIFICATION CONTROL DRAWING



D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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8

7

6

5

4

3

2

1

D

C

B

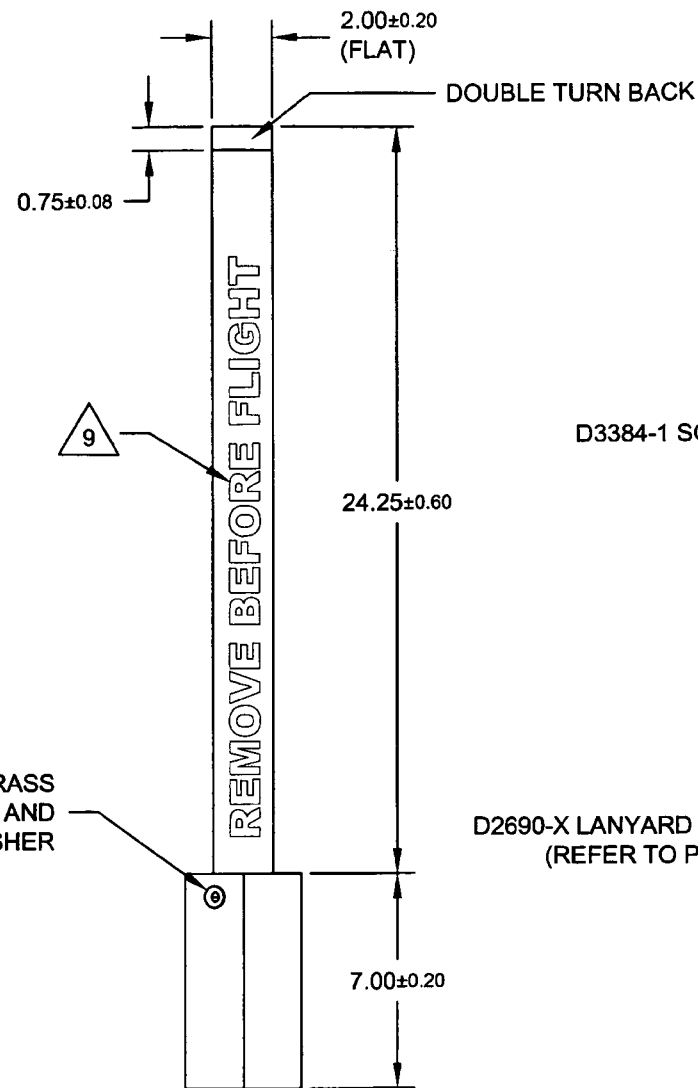
A

D

C

B

A

**D3384-1 SOCK**

D3384-1 SOCK

D2690-X LANYARD ASSEMBLY
(REFER TO PARTS LIST)**D3384-0XX SOCK ASSEMBLY**

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	P/N	DESCRIPTION
X					D3384-041	SOCK ASSEMBLY
	X				D3384-043	SOCK ASSEMBLY
		X			D3384-045	SOCK ASSEMBLY
			X		D3384-047	SOCK ASSEMBLY
				X	D3384-049	SOCK ASSEMBLY
	1				D2690-8	LANYARD ASSEMBLY
		1			D2690-20	LANYARD ASSEMBLY
1			1		D2690-24	LANYARD ASSEMBLY
				1	D2690-28	LANYARD ASSEMBLY
				1	D2690-30	LANYARD ASSEMBLY
1	1	1	1	1	D3384-1	SOCK

D3384-1 NOTES:

- SUPPLIER: TULMAR P/N 8972
MATERIAL: 420 DENIER NYLON CLOTH, PVC COATED, COLOUR RED
- THREAD: STITCHING IAW D-6193 6 TO 10 STITCHES PER INCH USING V-T-295 RED NYLON THREAD, TY2, CL A, SIZE E
- FINISH: NONE
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: NONE
- WEIGHT: N/A
- STENCIL THE FOLLOWING: "REMOVE BEFORE FLIGHT" ON BOTH SIDES OF STRIP WITH 1" LETTERS USING INK, WHITE, IAW A-A-208

B	CHG TOLERANCES DWG UPDATED ADD MATERIAL & SUPPLIER INFO	DC	07.11.23
A	NEW ISSUE	RF	05.01.20
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>TF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>LC</i>		
CHECKED	<i>LC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>LC</i>	D3384	SHEET 1 OF 1
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>N/A</i>	SOCK ASSEMBLY	NTS
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